

**Ship Via:**



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S190118



Part: D212-664-101

Job No: 196221

Serial No/Batch: S190118

Revision: E/J

Inspector:

Exp Date:

Instructions: TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA ST

					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
120	Crosstubes - Bend - 2 - B4B	1 pcs	7/19/19	3.11 1.00	Crosstubes - Bend - B4B	GP 19-06-13.
130	QC 15	1 pcs	7/19/19	0.00 0.00	QC 15 - 12	
					QC 15 - 3	DAS
					QC 15 - 47	47
					QC 15 - 49	9-89
					QC 15 - 58	
					QC 15 - 9	
					QC 15 - 68	
140	Crosstubes - 2 - B4B	1 pcs	7/19/19	0.00 1.00	Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	GP 19-06-17
					Crosstubes - 3 - B4B	
					Crosstubes - 4 - B4B	
150	Crosstubes - 3 - B4B	1 pcs	7/19/19	0.00 0.50	Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	GP 19-06-19.
					Crosstubes - 4 - B4B	
160	QC 7	1 pcs	7/19/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	JUN 25 2019
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
165	QC 5	1 pcs	7/19/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	

				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS JUN 25 2019 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
170 Outsource - 2 - NDT per QSI038	1 pcs	7/19/19		SKY002-VC	2019-06-26
180 Packaging 2-1 - Receive - B4B	1 pcs	7/19/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	JUN 27 2019
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
190 QC 5	1 pcs	7/19/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	

JUN 27 2019 68

9-89

				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
200	Spray Paint - 2 - B4B	1 pcs	7/19/19	0.00 0.25	Spray Paint - 1 - B4B
					Spray Paint - 2 - B4B
					Spray Paint - 3 - B4B
					Spray Paint - 4 - B4B
210	QC 14	1 pcs	7/19/19	0.00 0.00	QC 14 - 15
					QC 14 - 2
					QC 14 - 34
					QC 14 - 41
					QC 14 - 51
					QC 14 - 58
					QC 14 - 59
					QC 14 - 9
					QC 14 - 68
					QC 14 - 40
					QC 14 - 19
					QC 14 - 43
					QC 14 - 24
220	Crosstubes - 4 - B4B	1 pcs	7/19/19	0.00 1.69	Crosstubes - 1 - B4B
					Crosstubes - 2 - B4B
					Crosstubes - 3 - B4B
					Crosstubes - 4 - B4B
230	QC 5	1 pcs	7/19/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
240	Packaging 1-1 - Pick Kit - B4B	1 pcs	7/19/19	0.00 0.00	Packaging 1 - 1 - B4B
					Packaging 1 - 2 - B4B
					Packaging 1 - 3 - B4B
					Packaging 1 - 4 - B4B
					Packaging 1 - 5 - B4B
					Packaging 1 - 6 - B4B
					Packaging 1 - 7 - B4B
					Packaging 1 - 8 - B4B
					Packaging 1 - 9 - B4B
					Packaging 1 - 10 - B4B
					Packaging 1 - 11 - B4B
					Packaging 1 - 12 - B4B
					Packaging 1 - 13 - B4B
					Packaging 1 - 14 - B4B
					Packaging 1 - 15 - B4B
					Packaging 1 - 16 - B4B

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JUL 02 2019 68
9-89

				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	PC JUL 03 2019
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
250 QC 4	1 pcs	7/19/19	0.00 0.00	QC 4 - 28	DAS
				QC 4 - 58	75
				QC 4 - 69	9-89
				QC 4 - 9	
				QC 4 - 46	JUL 08 2019
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
260 Packaging 3-1 - Stock - B4B	1 pcs	7/19/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	DAS
				Packaging 3 - 4 - B4B	75
				Packaging 3 - 5 - B4B	9-89
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	JUL 08 2019
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
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				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	

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				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
265 DC - 1 - B4B	1	7/19/19	0.00 0.00	DC - 1 - B4B	21 JUL 09 2019
	pcs			DC - 2 - B4B	9-59
270 QC 21 - FG	1	7/19/19	0.00 0.00	QC 21 - FG - 21	
	pcs			QC 21 - FG - 70	DAS
				QC 21 - FG - 53	21 JUL 09 2019

Part Op 120 - Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio D212-664-101

Descriptions: 130 - (QC15- Crosstube Dimensional Check)

140 - "1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549, using drill table DT8577, set-up towers in hole #7 as per QSI 10 2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes. 3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-141 4-*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141"

150 - HandFinish5 (Crosstubes Chemical Conversion) ***IMMEDIATELY AFTER GRINDING***

160 - (QC7-Inspect Chemical Conversion Coat)

165 - QC5- Inspect part completeness to step on W/O)

170 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order

180 - (Receive & Inspect for Damage & Mat'l Certs) Ensure copy of NDT results attached to work order.

190 - (QC5- Inspect part completeness to step on W/O) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Inspect for damage & ensure results are as per Dwg D212-664-141

200 - (Spray Paint / NDT Room) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** 1-Prime inside & outside crosstube as per QSI 005 4.2 BATCH: 5154137 2- After painting remove masking and apply matte clear coat per QSI005 4.2 3- MASK UNDERSIDE OF CROSSTUBE AS SHOWN ON DWG BEFORE PAINTING 4 -Paint Outside of Tube as per Dart QSI 005 4.2 5178693

210 - (QC14- Inspect Spray Paint) Then, Wrap in plastic bag to protect from scratches

220 - *****LAY DOWN CROSSTUBE ON TABLE AND PUT DT10302 PINS IN SADDLE HOLE FACING UP, USE HOLE IN TAPE MEASURE TO PUT IN PINS FOR LOCATING CENTER OF CROSSTUBE. ***** 1- Abrade mating surfaces of support and crosstube with 180 grit sandpaper, clean the area with MEK or equivalent as per dwg 2- Install supports with Proseal 890 per D212-664-141 and QSI 015 A/R Proseal 890 Batch: 5176610 EXP: 10/19 PROSEAL CURE TIME 72 HOURS: Start: 19-6-21 Finish: 19-7-2 3- Install clamps with rubber cushion (ENSURE CLAMPS ARE INSTALL ON TOP SIDE OF CROSSTUBE) using DT9565 as per Dwg D212-664-141. ***Torque all clamps to 80-100 IN-LBS.***

230 - (QC5- Inspect part completeness to step on W/O) ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.***

240 - (Pick Kit)

250 - QC4- 100% Inspect kits for completeness) ***VERIFY BY _____ BATCH # TO MATCH W/O

260 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D212-664-101 Location : FG094

265 - Photocopy bluefile and create labels as per PPP D212-664-101 CHG006

270 - (QC21- Final Inspection - Work Order Release)

Job BOM

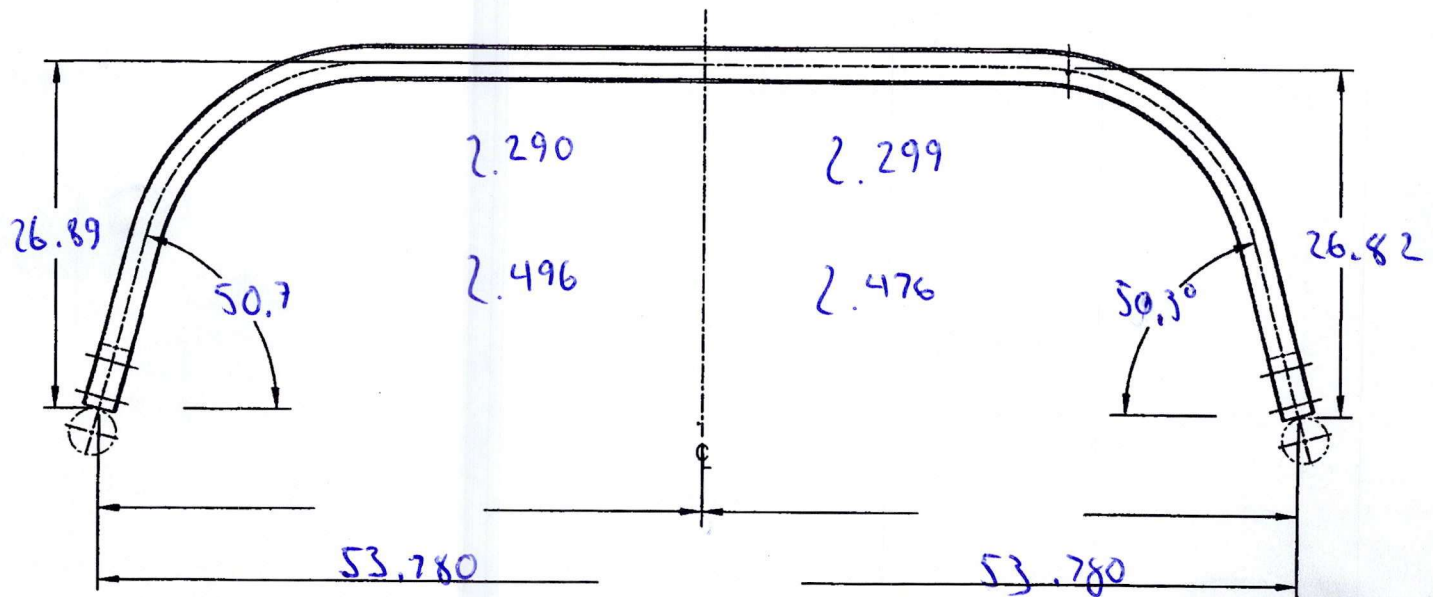
Part / Item	Component Name	Quantity	Operation	Container
D212-664-101TRN	Crosstube Turning Detail	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	<u>518478</u>
D2893-1	Support	2 pcs (2 ea)	220-Crosstubes - 4 - B4B	
D3595-063-450	Rubber Cushion 0.63" Wide X 4.50" Long	4 pcs (4 ea)	220-Crosstubes - 4 - B4B	
MS21920-25	Clamp	4 Ea (4 ea)	220-Crosstubes - 4 - B4B	
AN6-35A	Bolt	4 Ea (4 ea)	240-Packaging 1-1 - Pick Kit - B4B	<u>505411687</u>
AN6-36A	Bolt	4 Ea (4 ea)	240-Packaging 1-1 - Pick Kit - B4B	<u>5184941</u>
D3428-1	Placard	1 pcs (1 ea)	240-Packaging 1-1 - Pick Kit - B4B	<u>5112841</u>
MS21042L6	Nut	6 Ea (6 ea)	240-Packaging 1-1 - Pick Kit - B4B	<u>5182056</u>
NAS1149D0663J	Washer	18 Ea (18 ea)	240-Packaging 1-1 - Pick Kit - B4B	<u>5135108</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	D212-664-101TRN	1	8	0
220-Crosstubes - 4 - B4B	D2893-1 5188609	②	1	0
	D3595-063-450 5177076	④	41	0
	MS21920-25 5180180	4	103	0
240-Packaging 1-1 - Pick Kit - B4B	AN6-35A	4	55	0
	AN6-36A	4	49	0
	D3428-1	1	24	0
	MS21042L6	6	385	0
	NAS1149D0663J	18	894	0
Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD	Work Order: 194221
Description: Crosstube High Fwd (205/212/412)	Part Number: D212-664-101
Inspection Dwg: D212-664-141 Rev: E	Page 1 of 1

Required Dimension	Min	Max
Height	26.67	27.17
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.7
Bending Passes	3	--
Crushing	--	7.2%



	Side A	Side B
Bending Passes		
Crushing	4.30%	3.7%
Comments		

DAS
47

QC15 Inspection	9-89
Date	19-06-13

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	08.04.21	Dwg Rev updated	KJ/JM	
C	10.04.01	Dwg Rev updated	KJ	
D	12.04.16	Added bending, crushing dimensions	KJ	
E	14.07.28	Revised max crushing %	KJ	
F	16.01.15	Revised Height min/max dimensions	KJ	

Item	Qty -141	Qty -141B	Qty -141F	Part Number	Description
1	X			D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
2		X		D212-664-141B	CROSSTUBE ASSEMBLY (214 HIGH FWD)
3			X	D212-664-141F	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD) (ANODIZED)
4	1	1	1	D6005-128	CROSSTUBE
5	2		2	D2893-1	SUPPORT
6	4	4	4	D3595-063-450	RUBBER CUSHION
7		2		D5017-1	SUPPORT
8	4	4	4	MS21920-25	CLAMP (OR MS21920-26)
9	A/R	A/R	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6005-128
FINISHED LENGTH = 126.514±0.020
- 2) FINISH -141 & -141B: a) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
b) PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
c) MASK UNDERSIDE OF CROSSTUBE AS SHOWN (ZN C6-2 / C6-3, HATCHED AREA)
d) PAINT OUTSIDE PER DART QSI 005 4.2
e) REMOVE MASKING AND APPLY MATTE CLEAR COAT

- FINISH -141F: a) ANODIZE PER MIL-A-8625, TYPE II, CLASS 1.
b) ALODINE (DO NOT ETCH) PER QSI 005 4.1.2
c) PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
d) MASK UNDERSIDE OF CROSSTUBE AS SHOWN (ZN C6-2 / C6-3, HATCHED AREA)
e) PAINT OUTSIDE PER DART QSI 005 4.2
f) REMOVE MASKING AND APPLY MATTE CLEAR COAT

***NOTE:** BETWEEN FINISHING OPERATIONS EXTREME CARE MUST BE TAKEN NOT TO CONTAMINATE OR DAMAGE FINISHED SURFACES.

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS
- 7) WEIGHT: D212-664-141/-141B/-141F = 33.6 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

MACHINING

- 10) RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.

BENDING

- 11) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 7.2% (BASED ON O.D.) IN LOWER HALF OF R35.5 BEND AND 6% (BASED ON O.D.) ON REMAINING TUBE.
- 12) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.

ASSEMBLY

- 13) TO INSTALL D2893-1 / D5017-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 14) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE ON TOP SIDE OF CROSSTUBE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

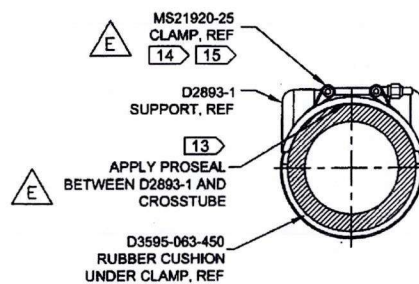
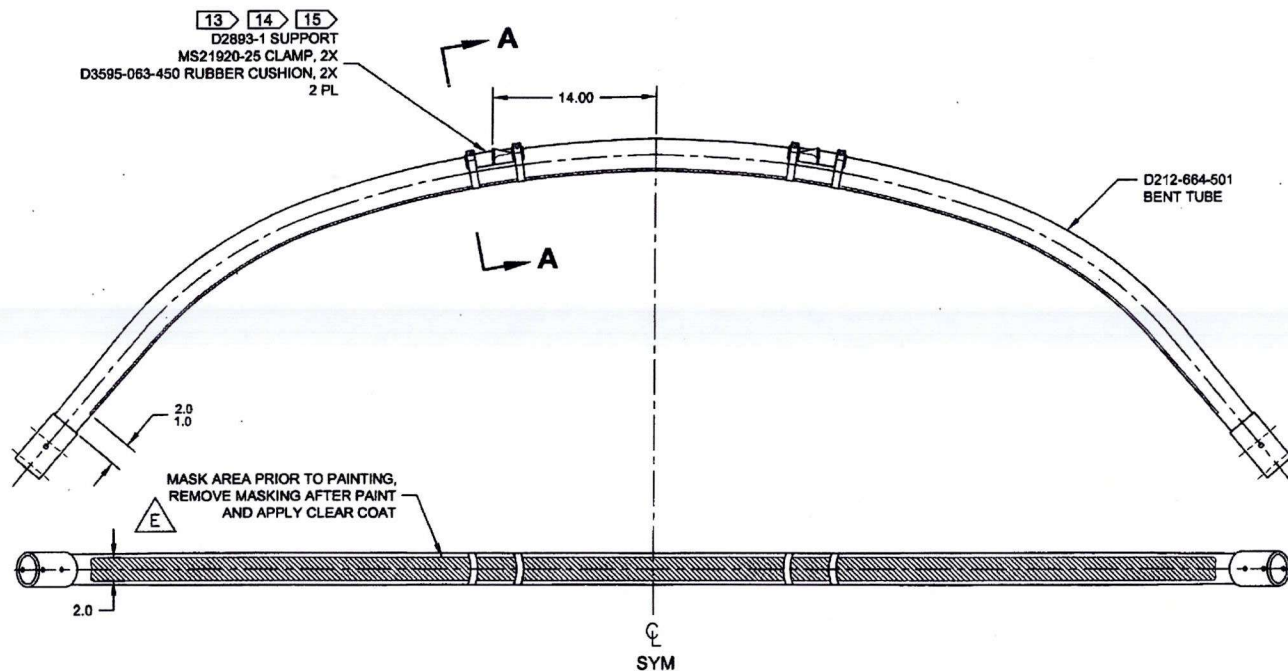
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WORK ORDER
NO. 1976221 MWS
19-06-16

RELEASED
2014-05-26
MD

E	ADD -141F, D5017-1 WAS D2893-1 (-141B), PROSEAL WAS MAGNOBOND, NOTE 2: ADD INSPECTION WINDOW, NOTE 11: ALLOW 7.2% CRUSH, NOTE 15: ADD 72HR CURE AND RETORQUE FOR PROSEAL, ADD SHEET 3, CLAMPS REVERSED TO PREVENT CHAFING (B7-2, B7-3), BEND HEIGHT TOL. NOW 0.25 WAS 0.13 (C1-3), INCOMP. DEO D-1/2-3	CP	14.04.01
D	REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -141B (ZN B4-2, D4-2); REMOVED REF & ADD TOLERANCES (ZN B4-3, C6-3, C8-3 & B6-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATIBILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	CP	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	14.04.01		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D212-664-141	REV. E SHEET 1 OF 5
TITLE XTUBE ASS'Y (205/212/412 HI FWD)	SCALE NTS
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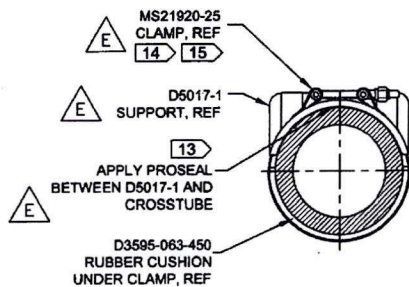
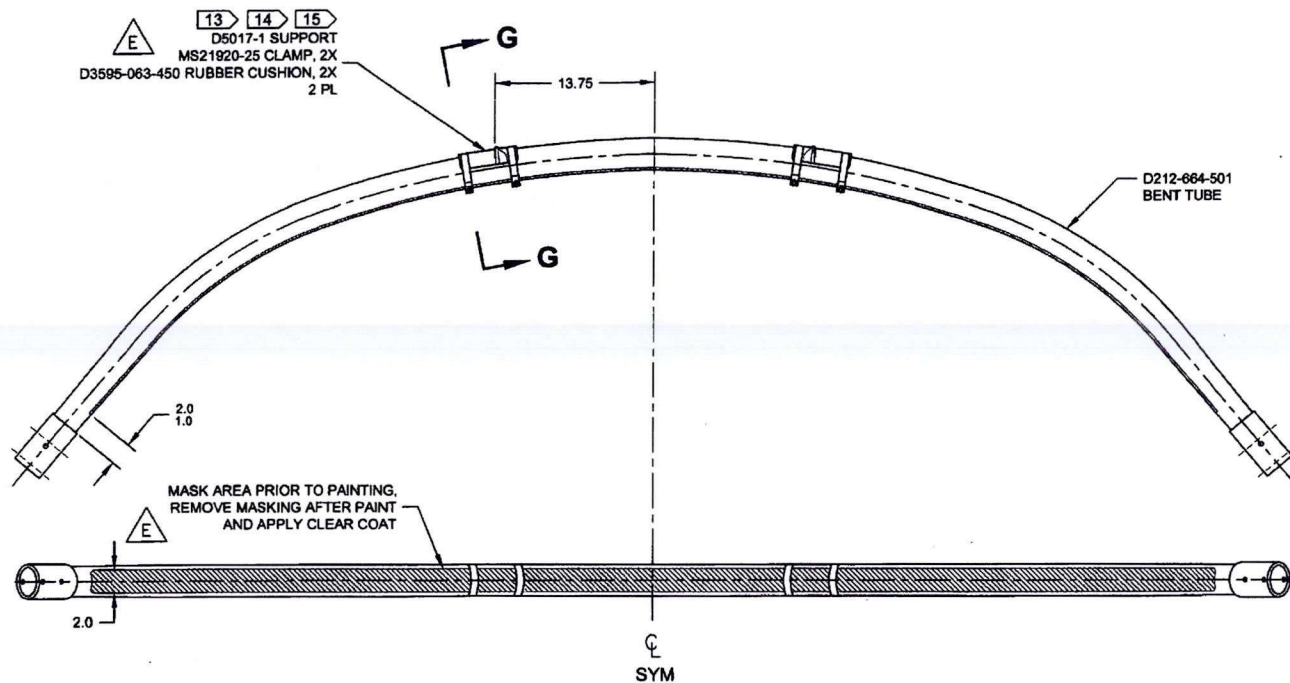
SECTION A-A
SCALE 4X

D212-664-141/-141F
ASSEMBLY DETAIL

RELEASED
2014-05-26
AND

DESIGN	Q	DART AEROSPACE LTD	
DRAWN	Q	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Q	DRAWING NO.	REV. E
MFG. APPR.	Q	D212-664-141	SHEET 2 OF 5
APPROVED	Q	TITLE	SCALE
DE APPR.	Q	XTUBE ASS'Y (205/212/412 HI FWD)	NTS
DATE	14.04.01	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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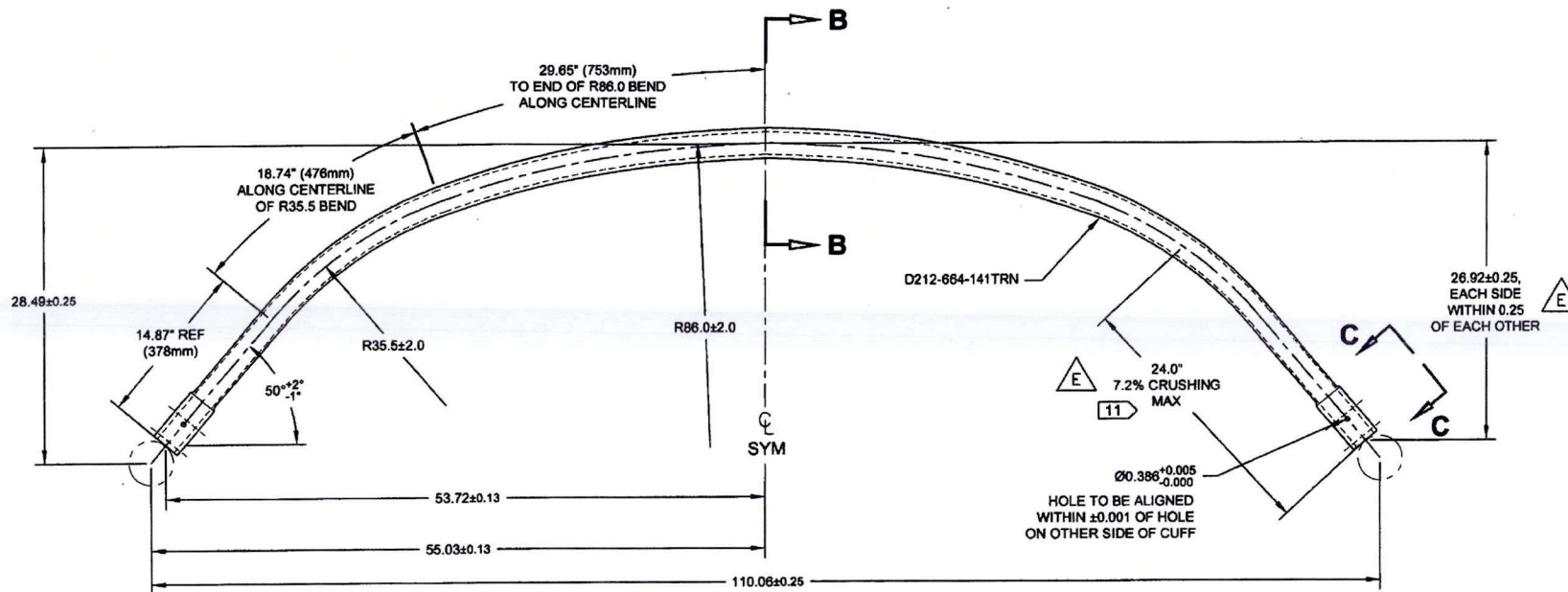


SECTION G-G
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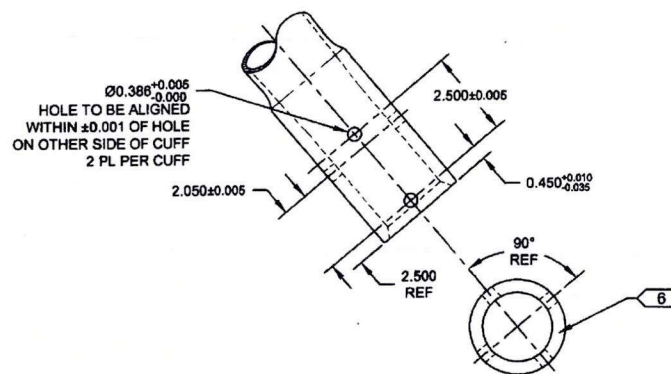
D212-664-141B
ASSEMBLY DETAIL

RELEASED
2014-05-26

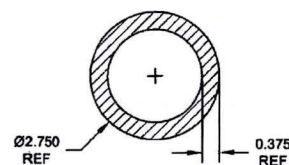
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D212-664-141	SHEET 3 OF 6
APPROVED		TITLE	SCALE
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D212-664-501
BENDING AND DRILLING DETAIL 11



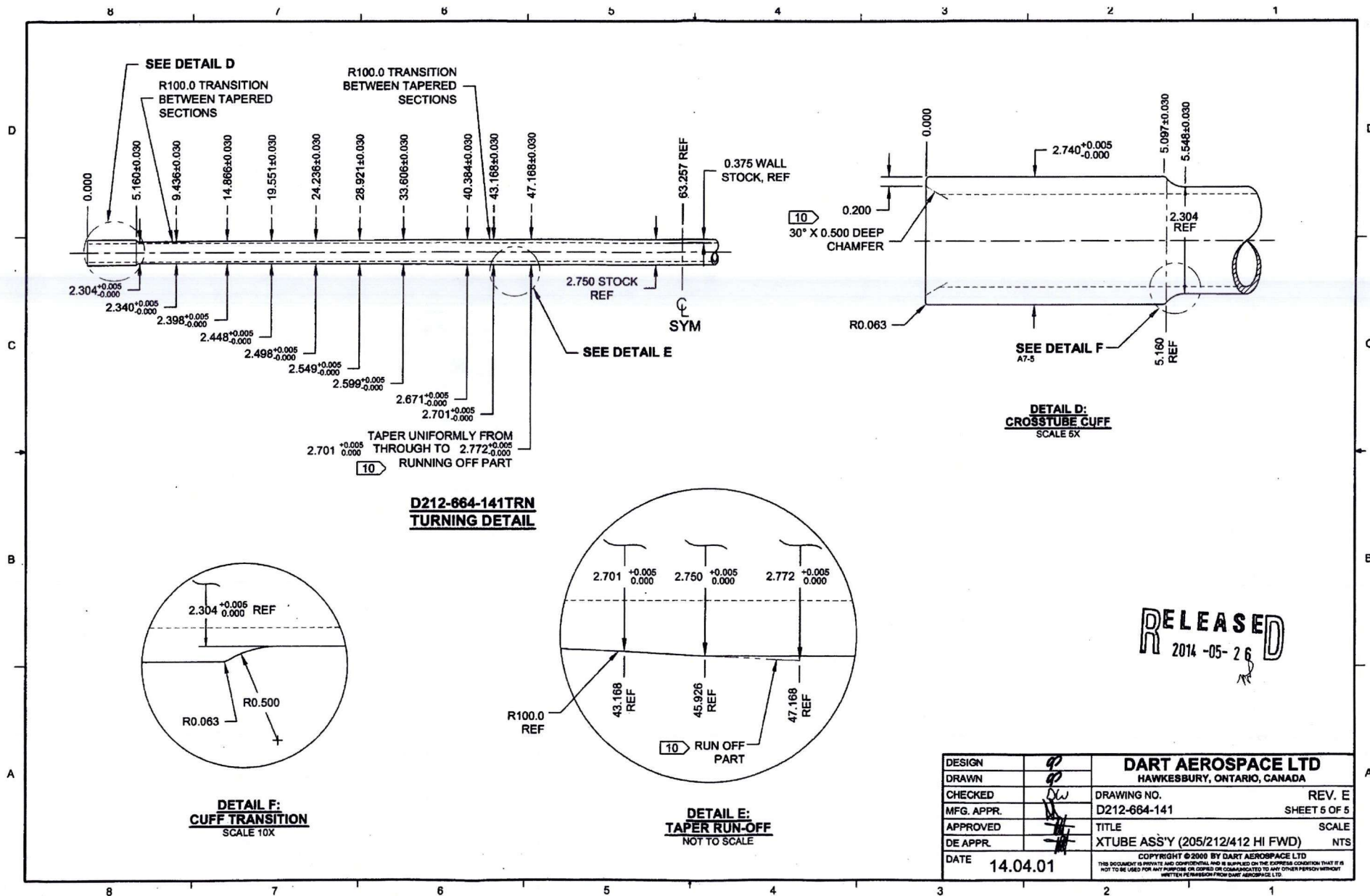
VIEW C-C: CUFF DETAIL
SCALE 3X



SECTION B-B
SCALE 4X

RELEASED
2014-05-26

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. E
MFG. APPR.	92	D212-664-141	SHEET 4 OF 5
APPROVED	92	TITLE	SCALE
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		Other/Details: _____ _____ _____			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043846



Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

Attention: Jenne, Heather

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043846

PO Date: 6/26/19

Due Date: 6/26/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	195827	D4464-041	Fuel Tank Assembly : Various STC's ISSUE P/O : LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	-	6/26/19	1 pcs	0 pcs	1 pcs	\$345.00/pcs	\$345.00
2	196220	D212-664-101	Fwd Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA- 316/2015 15/06/17 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	6/26/19	1 pcs	0 pcs	1 pcs	\$193.75/pcs	\$193.75
	196221			Firmed	-	6/26/19	1 pcs	0 pcs	1 pcs	\$193.75/pcs	\$193.75
	196362			Firmed	-	6/26/19	1 pcs	0 pcs	1 pcs	\$193.75/pcs	\$193.75
	196363			Firmed	-	6/26/19	1 pcs	0 pcs	1 pcs	\$193.75/pcs	\$193.75
Sub Total:							4	0	4		\$775.00

Grand Total: \$1,120.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043846



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/26/19 3:21 PM Dart.Guerin.Kimberley

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO40864	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: POHB043846 ✓
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	

Task: UNSCHEDULED	Sequence: 1
--------------------------	-------------

Work Required:**CARRY OUT NDT ON:**

✓ 1 FUEL TANK ASSY , P/N: D4464-041 , J/S: 195827 ✓

✓ 4 FWD CROSSTUBES , P/N: D212-664-101 , J/S: 196220 , 196221 , 196362 , 196363 ✓

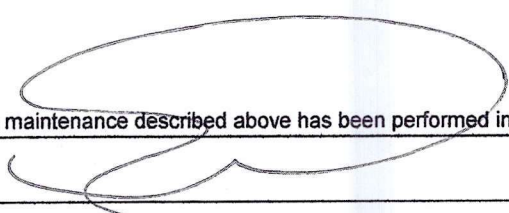
Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-16						JUN 26 2019	 DOT-APP 20 53-89
NO CRACK OR LEAK FOUND							
PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	
 345.00 tank 775 ÷ 4 = \$193.75							

RECEIVED

JUN 26 2019

DART AEROSPACE LTD.

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp DOT-APP 20 53-89	Date: JUN 26 2019
Name: RAFIK MELIKJAN		

PAGE 1 OF 1

Description: CROSSTUBE INSTALLATION, HIGH FWD

D212-664-101/196221/5190118